

Date: Wednesday, 06/05/2009 8:51:55 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BEARPAW INSTALLATION KIT (19"X24" BENT)	
<b>Job Number</b> :	47763			
<b>Estimate Number</b> :	12280			
<b>P.O. Number</b> :		<b>Part Number</b> :	D206559015	
<b>This Issue</b> :	06/05/2009	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2432 REV F3	
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :		<b>Drawing Revision</b> :	F3	
<b>Written By</b> :		<b>Material</b> :		
<b>Checked &amp; Approved By</b> :		<b>Due Date</b> :	13/05/2009	<b>Qty:</b> 3 <b>Um:</b> Each
<b>Comment</b> :	Est F 03.02.21 Reformat; Incorporated D2432B KJ/RF Est Rev:G 08-10-15 New Manufacturing Method JLM Verified By:EC			

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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*for JLD 09/05/13*

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-015 CHG004

*S 09/05/13*

2.0	MFG ENGINEERING	MFG ENGINEERING
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**Comment:** MFG ENGINEERING

Program Batch Number

*J.F.S. 09/05/07*

3.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 3.4091 sf(s)/Unit Total : 10.2274 sf(s)

Material: Black UHMW 1"

Cut 2 blanks per D206-559-015 Kit

(MUHMWB10)

Batch: *111354*

*B 9-5-8*



4.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

Cut Blank as per D2432 File

*B 9-5-8*

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Inspect material for defects or damage prior to machining

Machine as per Folio D2432 and Dwg D2432

Deburr

*JP 09/05/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 47763

Part Number: D206559015

Job Number:



Seq. #: Machine Or Operation: Description :

Bend as per Dwg D2432

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

88 09/05/12 -

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

88 09/05/13 (C)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit (Note: D2432B is on BOM as material listed in Step 3)

9.0

D2182B

Rubber Cushion



Comment: Qty.: 2.6000 f(s)/Unit Total: 7.8000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

45405

88 09/05/13 (XS)

10.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

344547

88 09/05/13 (XS)

11.0

D2432B

Bearpaw, 206



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

UHMW Bearpaw - Bent 24"

1347263

88 09/05/13 XS

12.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp

43840

88 09/05/13 (XS)

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part Number: D206559015

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
12 D2529 Washer 45388

SS 07/05/13 (X3)

14.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
12 AN4-15A Bolt M110399

SS 09/05/13 (X3)

15.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
12 AN4-17A Bolt M109061

SS 09/05/13 (X3)

16.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
24 AN960JD416 Washer M110363

SS 09/05/13 (X3)

17.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
12 MS21042L4 Nut (or -4) M110450

SS 09/05/13 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D206559015

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 09/05/13 (x3)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-559-015

Identify and Stock

Location: \_\_\_\_\_

Rev C

8 09/05/14 (5)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/21 J

Job Completion



MF 09-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47763
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2432
<b>Inspection Dwg:</b> D2432	<b>Rev:</b> F3	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.060 ✓			
B	5.500	+/-0.030	5.506 ✓			
C	0.200	+/-0.030	.200 ✓			
D	0.25 x 45°	+/-0.030	.250 ✓			
E	R0.250	+/-0.030	.250 ✓			
F	0.250	+/-0.010	.245 ✓			
G	0.625	+/-0.030	.620 ✓			
H	0.375	+/-0.010	.374 ✓			
I	0.950	+0.030/0.010	.949 ✓			
J	19.000	+/-0.030	19.00 ✓			
K	3.14	+/-0.030	3.137 ✓			
L	3.28	+/-0.030	3.300 ✓			
M	Ø0.260	+0.005/-0.000	.260 ✓			
N	Ø0.93	+/-0.030	.930 ✓			
O	0.30	+0.030/-0.000	.315 ✓			
P	23.750	+/-0.030	23.75 ✓			
Q	7.375	+/-0.030	7.378 ✓			
R	4.250	+/-0.010	4.250 ✓			
S	2.000	+/-0.030	2.015 ✓			
T	9.000	+/-0.010	9.00 ✓			
U	9.000	+/-0.010	9.00 ✓			
V	0.375	+/-0.010	.377 ✓			

<b>Measured by:</b> JLS	<b>Audited by:</b> JLS	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 02/05/12	<b>Date:</b> 09.05.13	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**DART****RELEASED**  
98.06.17 KE

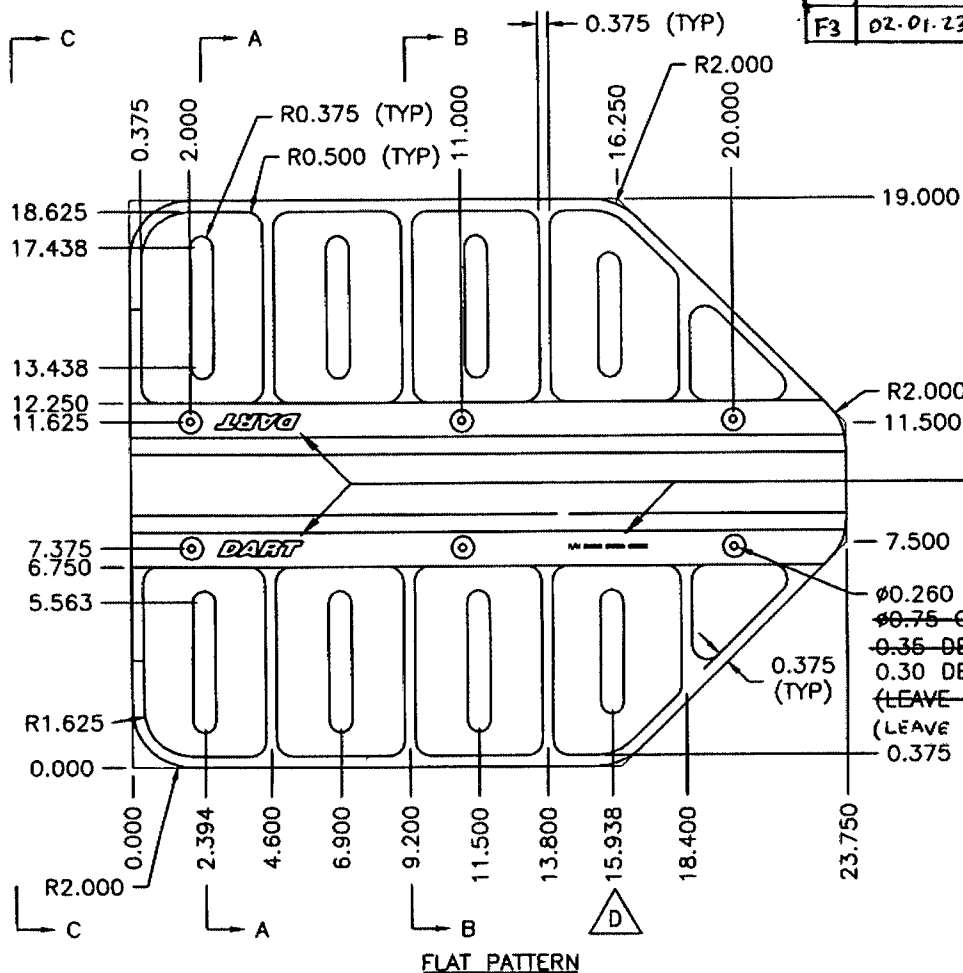
F1	99.03.03	ADD DEO 9143
F2	01.03.28	<del>Ø0.93 WAS Ø0.75</del> RF
F3	02.01.23	<del>CLARIFY BORE DIMS</del> RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
KE	KE		
CHECKED MM	APPROVED AS	DRAWING NO. D2432	SHEET 1 OF 2
DATE 98.05.12	TITLE BEARPAW	SCALE 1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

EFFECTIVE DEOS

9143	
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D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
111111

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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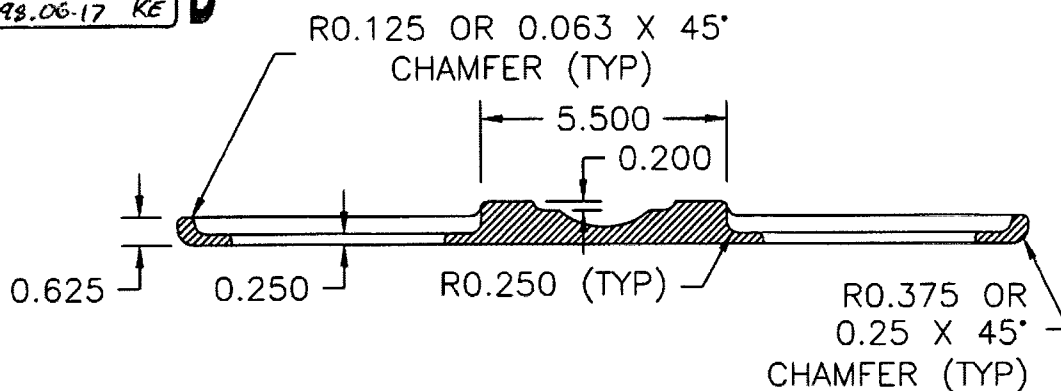
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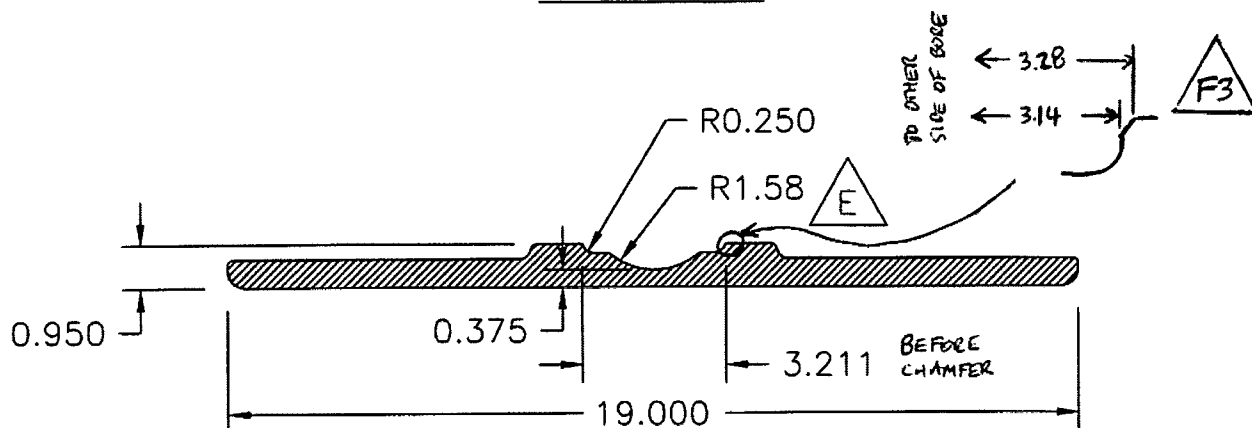


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

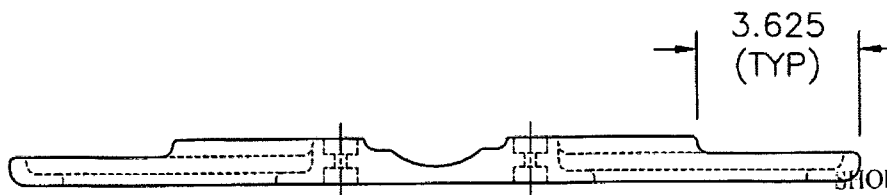
RELEASED  
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47763

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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